120

\*120\*

Quality Control

QC8- Inspect parts - second check

Memo

## Work Order ID 97261

\*97261\*

Page 1

February-14-13 1:27:19 PM Item ID: D2232-3 Accept \*N900040100\* Setup Start \* **Revision ID:** Item Name: Basket Hinge \*10\* Start Date: **Start Oty: 10.00** 2/14/13 **Cust Item ID:** Required Date: 2/26/13 Rea'd Otv: 10.00 **Customer:** Reference: Run Process Plan: MLJ Date: /3-02-15 Tooling: Approvals: Date: Stop Date: OC: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Set Up/ Tool # Plan Accept Reject Insp. **Work Center ID** Description Run Hours Oty Number Stamp Code Otv Draw Nbr **Revision Nbr** D2232 Rev C 100 0.00 FLOW WATER JET \*100\* Wateriet 0.00 1-Cut as per Dwg D2232 Dwg Rev: Prog Rev: 2-FLOW CNC Wateriet 304 125 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 \*110\* 10 OC 0.00 Memo Quality Control

0.00

0.00

											DQA:	Dat	te:			
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE			_				
,		<del>-,</del>						<del></del>			QA Closed:	Da	te:			
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Ord	C1.					Rework	7		Skid-tube Crosstu	he	1	Water Jet		Engineering		
Part	Nο.					Scrap	1	Machining Small Fab			Prod. Eng. Coor.			Quality		
					<del></del>	Use-as-is	·			-	4	e/Packaging		Other		
NCR	No.					Work Order Update	1	•	Large Fab Compos	~		Supplier	-			
										<b>L</b>			L	. —		
Root					Descri	ption of work order update		Initial	Action		Sign &	,				
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Description		Date	Verification	n	QC Inspector		
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier .	9															
Training																
Unapproved				<u> </u>			1_									
							AUI	LT CATE	GORY							
Landi	ng C	Gear				General		-			<b>-</b>			1		
		Bending				Bend	L	Grain			Ovalized		<u> </u>	Pressure/Forced		
		Centre N	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	L	Temperature/Cure		
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct		Weld		
		Crushed/	Crimped.		į	Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled		

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

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Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

150

\*150\*

Quality Control

Page 2

February-14-13 1:27:19 PM Item ID: D2232-3 Accept \*N900040100\* Setup Start Revision ID: Item Name: Basket Hinge Start Date: \*10\* 2/14/13 **Start Oty: 10.00** Cust Item ID: Required Date: 2/26/13 Rea'd Otv: 10.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Operation Sequence ID/ Tool # Set Up/ Tool ID Plan Reject Reject Insp. Accept Work Center ID Description **Run Hours** Qty Code **Qty** Number Stamp 130 0.00 Small Fab \*120\* Small Fab 0.00 Memo Small Fab Identify as per dwg & Stock Location: WA 140 0.00 (p(13.3.20 \*110\* Packaging 0.00 Memo \*\*\*\*\*STOCK IN BASKET CELL\*\*\*\*\* Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

(3-03-2) (3-03-2)

/es / 1	No.			WORK ORDER NON-	COI	NFORN	MANCE / UPI	DATE	QA Closed:	Date:	
er:				DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part No			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Small Fab Finishing	4	Engineering Quality Other			
			Descri	tion of work order update		Initial	Act	tion	Sign &		
Da	te Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
					AUI	LICATE	GORY				
Bend Centi Crack Crusk Cuffs Heat Inspe	e Not Conce is ned/Crimped Treat ction Strip in	i n Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	Unclear	Part Incorre Part Lost/M Part Moved Positioned N	ct issing	Pressure/Forced* Temperature/Cure Weld Wrong Stock Pulled Other
	ng Gear Bend Centr Crack Crush Cuffs Heat Inspe	ng Gear Bending Centre Not Conce Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend	Date Step Qty  Date Step Qty  Date Step Oty  Bending Centre Not Concentric to C Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Procession Strip in Tube	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Remork Scrap Use-as-is Work Order Update or Non-conformance  Remork Centre Not Conformance  Contract Scrap Scrap Use-as-is Work Order Update or Non-conformance  Remork Centre Not Conformance  Contract Scrap Scrap Use-as-is Work Order Update or Non-conformance  Remork Centre Not Conformance  Contract Scrap Scrap Scrap Use-as-is Work Order Update or Non-conformance  Contract Scrap Scrap Scrap Scrap Use-as-is Work Order Update Or Non-conformance  Remork Scrap Use-as-is Work Order Update Or Non-conformance	Part   Pa	Principles of the property of	Paris	Primary and the properties of	AGAINST DEPARTMENT,  Rework Scrap Use-as-is Work Order Update Or Non-conformance    Date   Step   Qty   Description of work order update or Non-conformance   Chief Eng   Description   Date	DISPOSITION  Rework   Scrap   Use-as-is   Work Order Update   Initial   Action   Date   Verification    Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification    FAULT CATEGORY  Read   General   Bending   Bend   Grain   Ovalized   Over/Under tolerance   Part Incorrect   Crushed/Crimped   Burrs   Instructions Incomplete   Part Incorrect   Part Incorrec

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

February-14-13 10:55:08 AM

Work Order ID:

97261

Parent Item:

D2232-3

Parent Item Name:

Basket Hinge

**Start Date: 2/14/13** 

Required Date: 2/26/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP B01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA	. 10 Marie 2411 Mar. 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Purchased	No			100	sf	266.5500	0.0694	0 <del>.7305</del> 26			JMJ8-3-
304/316 0.125 Sheet							•	6.1		1.0		and the second of the second o	, 1
				Location		Loc Qty	<u>Lo</u>	c Code					M1 13.93.1
				MAT020		266.55				<del></del>			
				1225	521	74.55			199	1821			
				2444	15	192							

												DQA:	D;	ate: ˈ_		
NCR:	es /	No				WORK ORDER NON-C	ON	NFORM	AANCE / UP	DATE		OA Classic		_4		
												QA Closed:	U:	ate:		
Morte Onde	~~.					DISPOSITION				AGAINST I	DEI	EPARTMENT/PROCESS				
Work Orde	er:				<del></del>	Rework	i		Skid-tube	Crosstube	_		Water Je	+	Engineering	
Part N	do.					Scrap			Machining .	Small Fab	$\dashv$	Pro	d. Eng. Coor		Quality	
raiti	···				<del></del>	Use-as-is			noforming	Finishing	$\dashv$		e/Packaging	-	Other	
NCR N	No.					Work Order Update			Large Fab	Composite			Supplie	_		
		<u> </u>				' <del>'</del>	1		• Ш							
Root				1	Descri	ption of work order update		nitial	Act	tion		Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on_	QC Inspector	
Doc/Data																
Equip/Tooling																
Operator	Ш															
Material												:				
Setup									-					}		
Other																
Process				·			ļ									
Supplier														į		
Training																
Unapproved				<u> </u>	,		<u> </u>								<u> </u>	
					,		AUL	T CATE	GORY							
Landi	ng Gea					General		1		ı		1			1	
	Bending			<u> </u>	Bend		Grain				Ovalized		<u> </u>	Pressure/Forced		
	LCe	ntre No	t Conce	ntric to	O/S	BOM/Route		Hardware				Over/Under		$\vdash$	Temperature/Cure	
	⊢	acks			<u> </u>	Broken/Damaged	<u> </u>	1	on Incomplete			Part Incorre		<u> </u>	Weld	
			Crimped		<u> </u>	Burrs	<u></u>	1	ions Incomplete/	Unclear		Part Lost/M	issing	L_	Wrong Stock Pulled	
	Cu	ffs			1	Contamination		Mainte	nance			Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	97261
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 Rev: C		Page 1 of 1

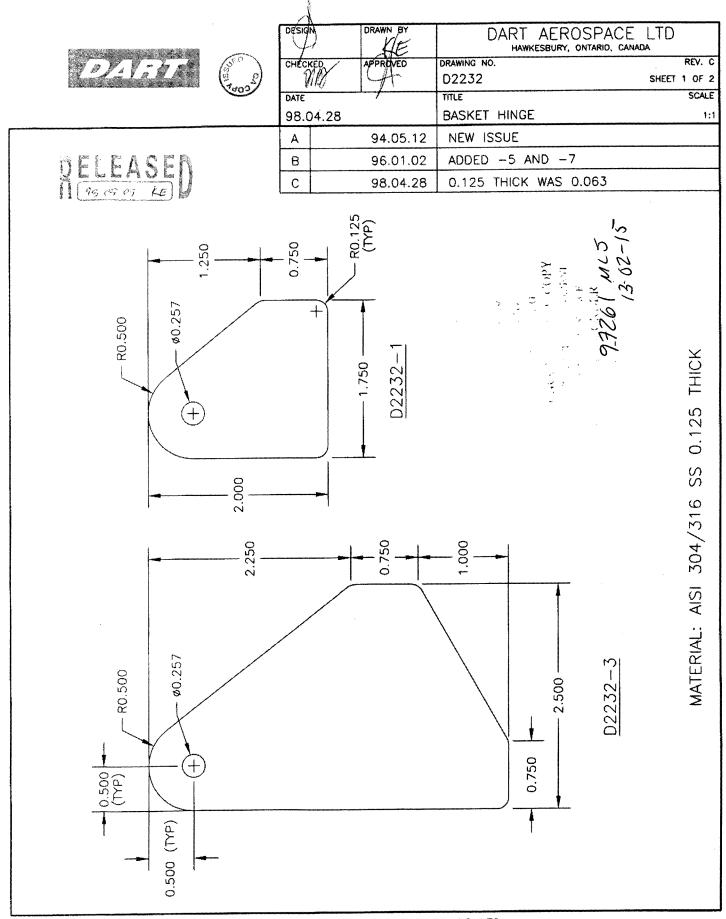
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
0.500	+/-0.010	0.500	1		Verv	MM-01			
0.750	+/-0.010	0.750			Vin				
2.500	+/-0.010	2.502	/		ven				
1.000	+/-0.010	1.000	1		VerN				
0.750	+/-0.010	0.750	1		ven				
2.250	+/-0.010	2.250	V		Ver				
0.500	+/-0.010	0.500			Vers Vers				
Ø0.257	+0.006/-0.001	0.256	1		Ver				
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Measured by:	what	Audited by:	(35)	Prototype Approval:	N/A
Date:	13.03.15	Date:	13-03-13	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.08	New Issue	KJ/JLM ox	E
			· ()	



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